



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE332A94-3400-03-19**Job Sheet 199369****Part No:** RBE332A94-3400-03-19**Job Qty:** 3 pcs**Part Name:** Target Block 1 Fabrication**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/21/19**Job Tracking No:****Due Date:** 11/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD**Ship Via:****Bill of Materials**

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S211404**Part:** RBE332A94-3400-03-19**Job No:** 199369**Serial No/Batch:** S211404**Revision:** A**Inspector:****Exp Date:****Instructions:****Date:** 09/04/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	Sign-off
100	Small Fab - 1	3 pcs	11/22/19		0.00	0.60	Small Fab - 1	MLL
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
							Small Fab - 8	
110	QC 5	3 pcs	11/22/19		0.00	0.00	QC 5 - 10	DAS 40 9-89 SEP 04 2019
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
120	Packaging 3-1 - Stock - B4B	3 pcs	11/22/19		0.00	0.00	Packaging 3 - 1 - B4B	DAS 28 9-89
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
130	QC 21 - SA	3 pcs	11/22/19		0.00	0.00	QC 21 - SA - 21	DAS 21 9-89 SEP 05 2019 A140B
							QC 21 - SA - 70	
							QC 21 - SA - 53	

Part Op 100 - 1-Do NOT remove clear protective film prior to assembly. 2-Assemble as per DWG. See note 8 and 9.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
65 90591A171	Hex Nut	9 Ea (3 ea)	100-Small Fab - 1	FM13894-8
70 91280A636	Hex Head Cap Screw	9 Ea (3 ea)	100-Small Fab - 1	5157274
40 98023A031	Yellow Zinc Plated Grade 8 Steel Washer 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.	9 Ea (3 ea)	100-Small Fab - 1	5157242
140B RBE332A94-3400-03-20	Base	3 pcs (1 ea)	100-Small Fab - 1	5165283

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A171	9	64	0
	91280A636	9	49	0
	98023A031	9	64	0
	RBE332A94-3400-03-20	3	3	0

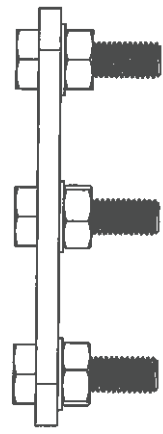
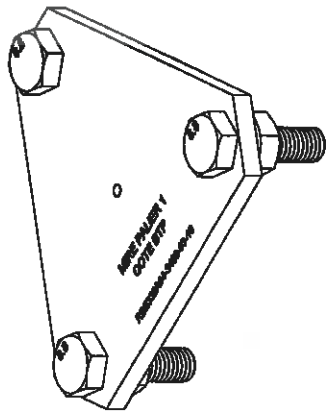
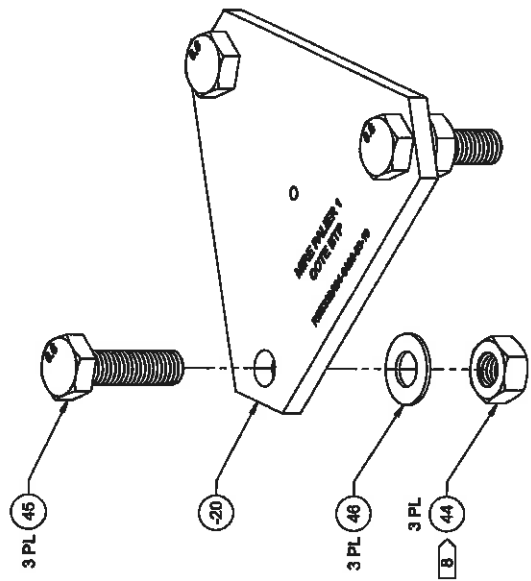
Part Specifications

Specifications could not be found.

Plex 8/21/19 7:59 AM Dart.lajeunesse.marie

8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-20	1	RBE332A94-3400-03-20	BASE
44	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
45	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
46	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.408" ID. X 0.812" OD. X 0.051"-0.080" THK.



RBE332A94-3400-03-19 TARGET BLOCK 1 FABRICATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 44 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

WORK ORDER
NO. 199369 HUS
19-08-21

DESIGN	KPT	DATE	2/14/2019
DRAWN	KPT		
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	WY		
TOOL PART #		RBE332A94-3400-03	
TITLE		T/R DRIVE ALIGNMENT INSPECTION	
SCALE		NTS	
REV. A		SHEET 20 OF 26	
DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS				MRB (QS1042)	
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	MRB (QS1042)	
Date: _____	Sequence #: _____	QTY Affected: _____		Disposition			
Description Work Order Deviation		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			